

5/21

split up

DART AEROSPACE LTD	Work Order:	23199 B
Description: Door Assembly	Part Number:	D3296-041
Dwg: D3296 Rev. A	Qty:	to 30 20
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler Note: To be made in multiples of 10	AP	05/05/09	to 30																
2	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1 Batch: <u>M16807</u>	JL	05/05/18	30																
3	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-3 Batch: <u>M16807</u> <u>M16645</u>	JL	05/05/18	30																
4	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-1	JL	05/05/18	30																
5	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30																
6	QC8	Second check	SD	05/05/18	30																
7	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-3	JL	05/05/18	30																
8	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30																
9	QC8	Second check	SD	05/05/19	30																
10	GA	Deburr D3296-1/-3	FF	05/05/25	30																
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05/06/2	30																
12	QC3	Inspect Chemical Conversion Coat	SB	05/06/14	30																
13	GA	Assemble hinges as per Dwg D3296 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3161-7</td><td>Hinge</td><td>B 22980 B 23567</td></tr><tr><td>1</td><td>D3161-9</td><td>Hinge</td><td>B 23203</td></tr><tr><td>25</td><td>MS20470AD4-4</td><td>Rivet</td><td>M16199</td></tr></table> <i>add to stock</i>	Qty	Part Number	Description	Batch	1	D3161-7	Hinge	B 22980 B 23567	1	D3161-9	Hinge	B 23203	25	MS20470AD4-4	Rivet	M16199	SP	05/08/18	30
Qty	Part Number	Description	Batch																		
1	D3161-7	Hinge	B 22980 B 23567																		
1	D3161-9	Hinge	B 23203																		
25	MS20470AD4-4	Rivet	M16199																		
14	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05/08/30	30																
15	QC3	Inspect Powder Coat	ML	05/08/31	30																

RELEASED

by Date Qty

12 05-08-25/201

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-18	13b	Inspection before powder coat. Permanent Change 2	TE	05.09.27		18 05/09/27	2 05-08-18	
05-06-16	13	MADE 5 x D3161-7 hinge with MS20257-3-2200 Batch M17808	SP	05/08/16	5	18 05/08/16	2 05-08-16	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/18	4	-1 stack / longer of .030 each side.	18 05/05/18	acceptable	18 05-05-18	18 05-05-18	18 05-05-18	2 05-05-18
05/05/18	7	-1 stack moved while machining .300 for holes are off.	18 05/05/18	Scrap & replace	18 05/05/19	2 05-05-19	18 05/05/19	2 05-05-19
05/08/16	13	made by hand 5 D3161-7 with P/W MS20257-3-2200 B/W M17808						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23199
Description: Door Assembly	Part Number:	D3296-041
Dwg: D3296 Rev. A	Qty:	10
Page 2 of 2		





Step	Location	Procedure	By	Date	Qty																																												
16	GA	Fabricate & assemble as per Dwg D3296. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2137</td><td>Decal</td><td>B19658</td></tr><tr><td>1</td><td>D2419</td><td>Handle</td><td>B23080/B25200</td></tr><tr><td>1</td><td>D2462-0040</td><td>Seal</td><td>B22749</td></tr><tr><td>1</td><td>D2462-0053</td><td>Seal</td><td>B22749</td></tr><tr><td>1</td><td>D2462-0245</td><td>Seal</td><td>B22749</td></tr><tr><td>1</td><td>D2728-1</td><td>Decal</td><td>M17991</td></tr><tr><td>1</td><td>D3296-1</td><td>Door Panel</td><td>B23199</td></tr><tr><td>1</td><td>D3296-3</td><td>Door Panel</td><td>B23199</td></tr><tr><td>1</td><td>AN960JD6</td><td>Washer</td><td>M6085</td></tr><tr><td>1</td><td>MS20470AD4-6</td><td>Rivet</td><td>M15924</td></tr></table>	Qty	Part Number	Description	Batch	1	D2137	Decal	B19658	1	D2419	Handle	B23080/B25200	1	D2462-0040	Seal	B22749	1	D2462-0053	Seal	B22749	1	D2462-0245	Seal	B22749	1	D2728-1	Decal	M17991	1	D3296-1	Door Panel	B23199	1	D3296-3	Door Panel	B23199	1	AN960JD6	Washer	M6085	1	MS20470AD4-6	Rivet	M15924	DK/ml	05/09/07	20
Qty	Part Number	Description	Batch																																														
1	D2137	Decal	B19658																																														
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1	D3296-1	Door Panel	B23199																																														
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1	AN960JD6	Washer	M6085																																														
1	MS20470AD4-6	Rivet	M15924																																														
17	QC5	Inspect work to Step 20	J	05-09-19	20																																												
18	ST	Identify and Stock	CL	05/09/26	20																																												
19	AC	Cost / part: 95.12	SAC	05-09-29	20																																												
20	DC	Close W/O 87.73 Inspect Level 21	D	05/09/27	20																																												

PTO

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	
B	04.11.26	Revised Steps 13-17	KJ/JLM	

RELEASED
05/11/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-19	16	Stickers don't stick so glued to powder coat		ADD A drop of crazy glue under ends on Labels. N 18229	SB 05/09/19			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

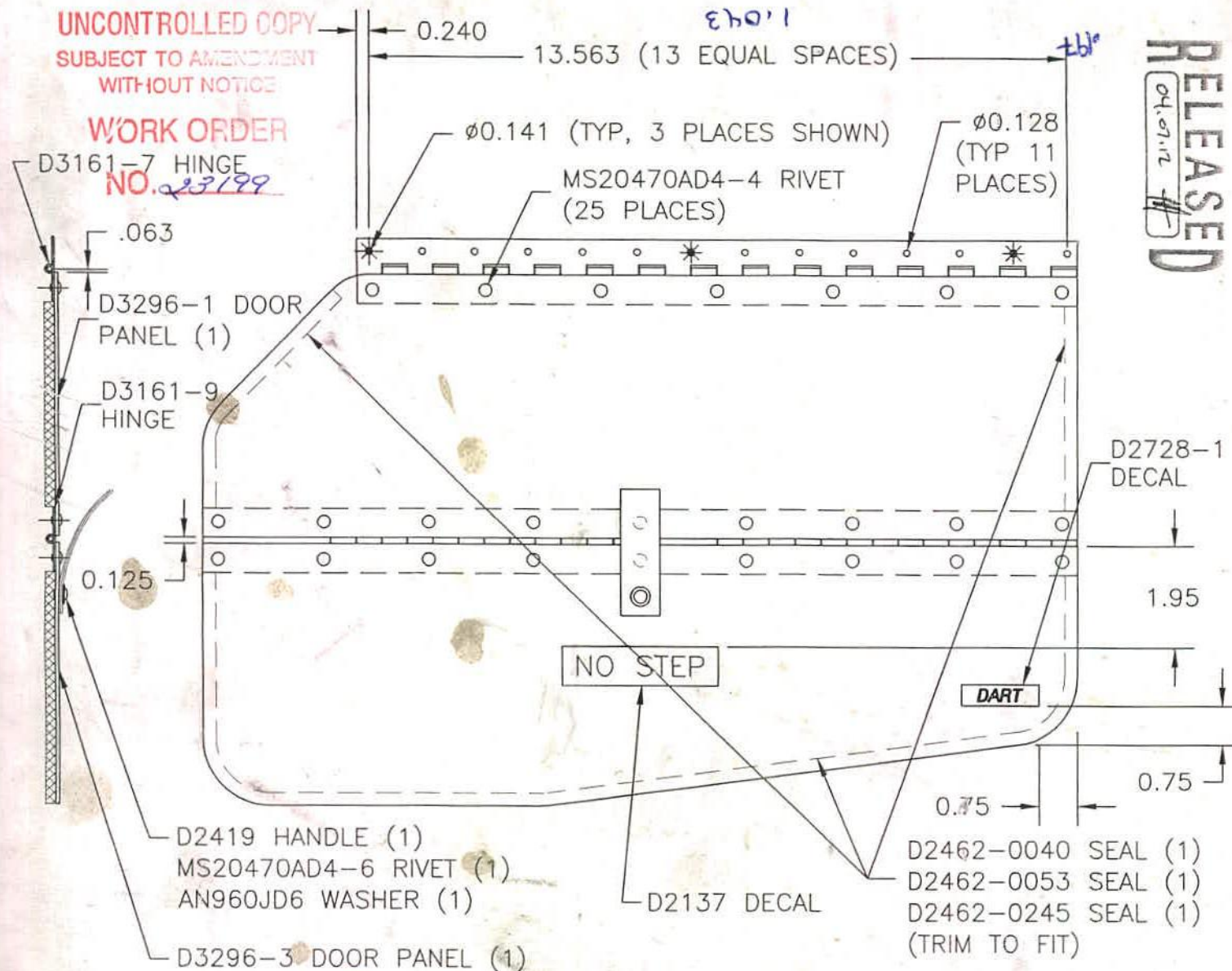
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WORK ORDER

D3161-7 HINGE
NO. 23199



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

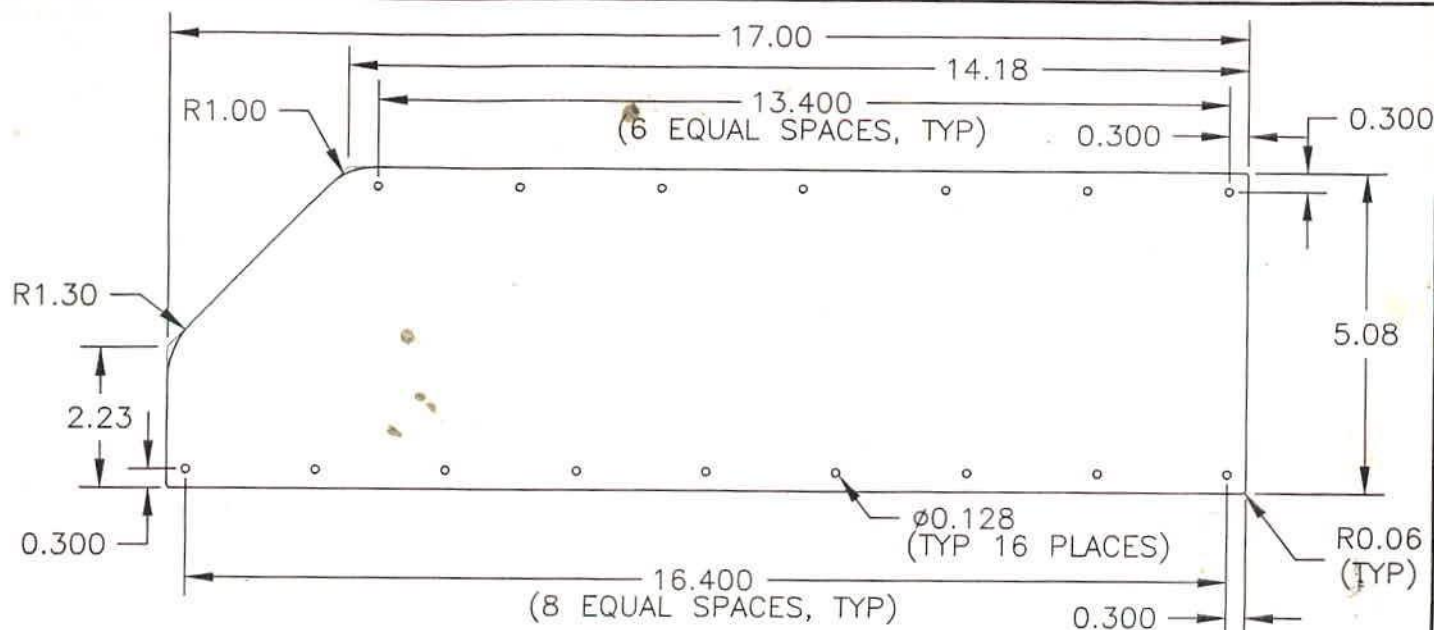
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QA COPY ISSUED

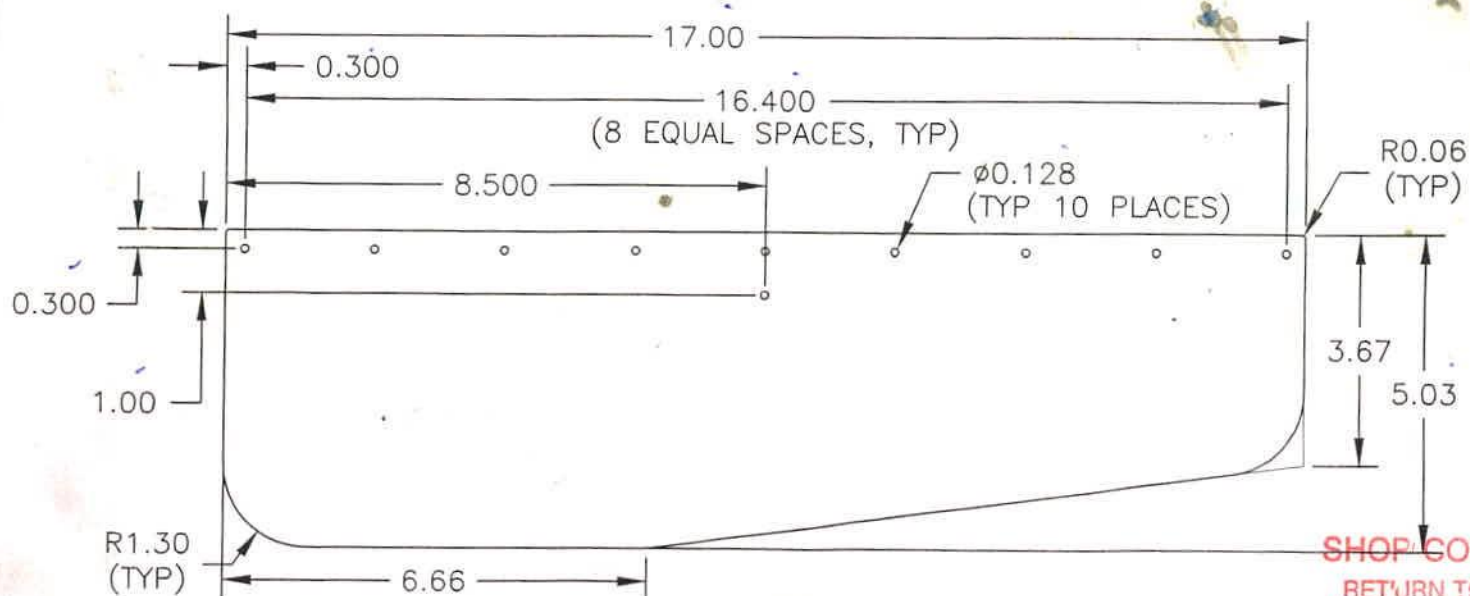
DESIGN	CH	DRAWN BY	CH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CH	APPROVED	CH	
DATE	04.06.28	DRAWING NO.	D3296	REV. A
		TITLE	DOOR ASSEMBLY	1 OF 2
			NEW ISSUE	SCALE
				1:3



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 23199

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023199
Project Name : D3296-041
Project For : WK521
Work Order Type : Main
Main WO Number :
House Part Number : D3296-041
Description : Door Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 05-26-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

